

Work Order ID 54822

December 22, 2009 1:28:34 PM



Page 1

Item ID: D3695-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Slider

Start Date: 1/05/10

Start Qty: 4.00 *6.00*



Cust Item ID:

Required Date: 1/15/10

Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: *CL*

Date: *09/12/23* Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3695

Rev C

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank 9.450" long

SP 10/01/11

4

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA739 Rev: *AA* & Dwg D3695 Rev: *C* 112-Deburr
per dwg D3695 113-Manually Tap for 10-32 heli coil

10/01/12

4 2 (acceptable)

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

10/01/12

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3695-1 PAR #: N/A Fault Category: Machine NCR: (Yes) No DQA: if Date: 10.01.19
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: if Date: 10/01/26

NCR: <u>54822</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/01/11	110	Two part have multiple error on It. hole of .203 was .210 dimension of 3.750 was 3.742.	<u>10/01/13</u>	Replace Batch 105338x2	<u>if</u> 10/01/11	<u>8</u> 10/01/13	<u>if</u>	<u>5</u> 10/01/13
		R.C. Drill problem feed too fast. change drill. R.C. process for dim 3.750.	<u>10/01/13</u>					
10/01/13	110	TWO PART WITH HOLES ϕ 0.210 INSTEAD OF ϕ 0.203, AND 3.750 IS UNDER TOLERANCE QTY.1 AND ABOVE TOL QTY.1	<u>10/01/13</u>	ACCEPTABLE DEVIATION. TAP HOLES PER DING.		<u>5</u> 10/01/13	<u>10/01/13</u>	<u>6</u> 10/01/13

NOTE: Date & initial all entries

R.C. SEE NC

ABOVE, SAME ISSUE.

Work Order ID 54822

December 22, 2009 1:28:35 PM

Page 2

Item ID: D3695-1

Accept

Revision ID:

Item Name: Slider

Start Date: 1/05/10

Start Qty: 4.00

Required Date: 1/15/10

Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Powdercoat

Memo

0.00

Powder Coating

****mask threaded holes*****[START TIME:
3:00pm OVEN TEMPERATURE: 3:20pm FINISH
TIME: 3:20pm

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54822

December 22, 2009 1:28:35 PM



Page 3

Item ID: D3695-1

Accept



Setup Start



Revision ID:

Item Name: Slider

Stop



Start Date: 1/05/10

Start Qty: 4.00



Cust Item ID:

Required Date: 1/15/10

Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

[Signature]

10-01-15

6

170



Packaging

Packaging

Identify as per dwg & Stock Location: 235

Memo

0.00

0.00

10-1-15

60 SP

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

10/01/18 *[Signature]*
MF 10-1-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 22, 2009 1:28:33 PM

Page 1

Work Order ID: 54822



Parent Item: D3695-1



Parent Item Name: Slider

Start Date: 1/05/10

Required Date: 1/15/10

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B2.000X01.25 0		Purchased	No				f	19.7474	3.3617			



6061-T6 Bar 2.00 x 1.25

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

19.74736842

105838

12

110936

7.74736842

3.3617

S.F 10/01/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	54822
Description: Slider		Part Number:	D3695-1
Inspection Dwg: D3695 Rev: C		Page 1 of 1	

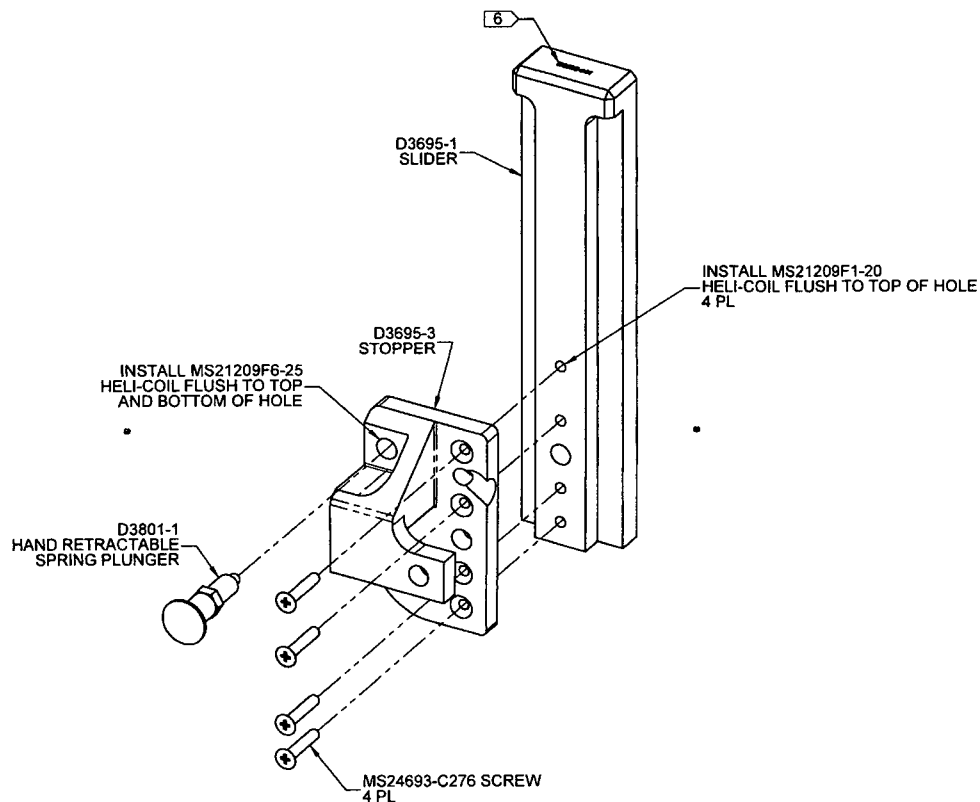
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.000	+0.000/-0.010	.999	✓			
0.500	+/-0.010	.499	✓			
0.300	+/-0.010	.298	✓			
0.485	+0.000/-0.010	.482	✓			
2.000	+0.000/-0.010	1.995	✓			
8.750	+0.005/-0.000	8.755	✓			
Ø0.386	+0.006/-0.001	.390	✓			
Ø0.203	+0.005/-0.001	.206	✓			
0.738 deep	+/-0.010	.729	✓			
0.500	+/-0.010	.490	✓			
0.450	+/-0.010	.453	✓			
2.025	+/-0.010	2.026	✓			
0.675 pitch	+/-0.010	.672	✓			
1.075	+/-0.010	1.076	✓			
R0.25	+/-0.030	.25	✓			
0.13 x 45°	+/-0.030 x 0.5°	.130	✓			
0.900	+/-0.010	.895	✓			
9.25	+/-0.030	9.248	✓			
0.50	+/-0.030	.520	✓			
0.875	+/-0.010	.877	✓			
0.310 deep	+/-0.010	.311	✓			
4.75	+/-0.030	4.749	✓			
1.06	+/-0.030	1.062	✓			
1.000	+/-0.010	.995	✓			

Measured by: <i>SB</i>	Audited by: <i>K.A</i>	Prototype Approval:	N/A
Date: 10/01/11	Date: 10/01/13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.11	New Issue	KJ <i>[Signature]</i>	<i>[Signature]</i>



D3695-041 SLIDER ASSEMBLY

D3695-041 NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3695-041" USING FINE POINT PERMANENT INK MARKER LOCATED APPROXIMATELY AS SHOWN
- 7) WEIGHT: D3695-041 = 0.64 lbs

ITEM	QTY	P/N	DESCRIPTION
1	X	D3695-041	SLIDER ASSEMBLY
11	1	D3695-1	SLIDER
12	1	D3695-3	STOPPER
15	1	D3801-1	HAND RETRACTABLE SPRING PLUNGER
21	4	MS21209F1-20	HELI-COIL, SCREW LOCKING (RED)
22	1	MS21209F6-25	HELI-COIL, SCREW LOCKING (RED)
23	4	MS24693-C276	SCREW

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WITHOUT NOTICE
WORK ORDER
NO. 54822
CX09112123

RELEASED
9/2/05 NTP

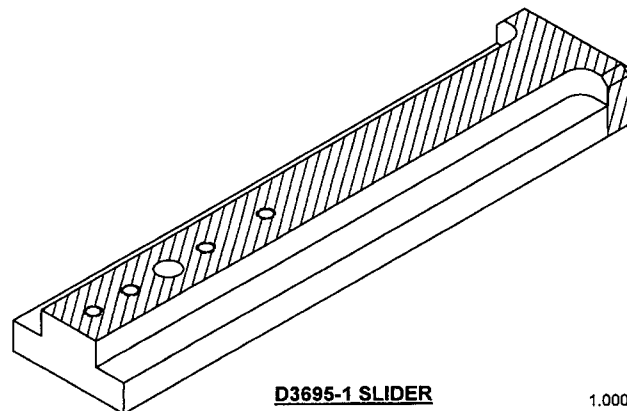
C	UPDATED BOM TO CURRENT STANDARDS; REVISED ITEM 12 (ZN D3-1); DIMS 1.83 AND 1.075 _{±.005} WERE 1.81 AND 1.063 _{±.005} (ZN B6-3 AND C4-3) REASON: COMPENSATE FOR PAINT THICKNESS AND ELIMINATE RATTLE UPON ASSEMBLY.	MB	08.11.04
B	P/N D3808-1 WAS WIP-510 (ZN C7-1 AND D3-1) - REASON: PURCHASED PARTS NOW PROCURED THROUGH D3801 SPEC CONTROL DRAWING	MB	08.06.26
A	NEW ISSUE	MB	08.03.14
REV.	DESCRIPTION	BY	DATE
DESIGN	1		
DRAWN	1		
CHECKED	1		
MFG. APPR.	1		
APPROVED	1		
DE APPR.	1		
DATE	08.11.04		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

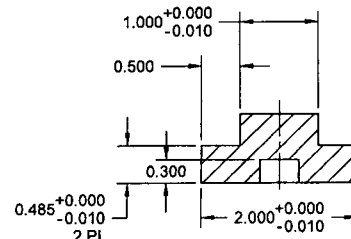
DRAWING NO. **D3695** REV. C
SHEET 1 OF 3

TITLE **SLIDER ASSEMBLY** SCALE NTS

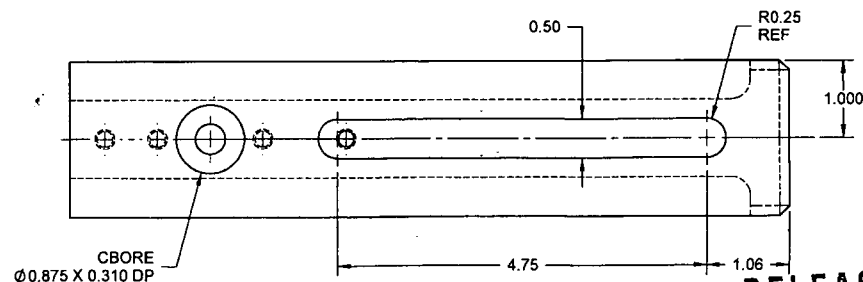
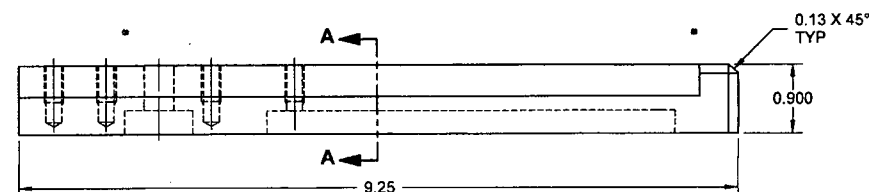
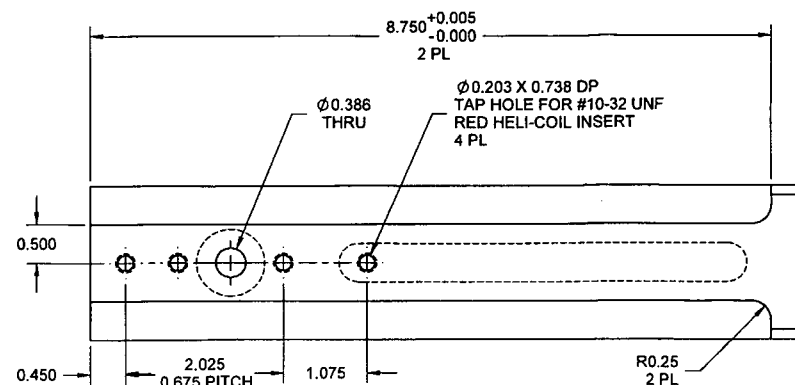
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D3695-1 SLIDER



SECTION A-A



D3695-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART
QSI 005 4.3 - MASK ALL HOLES AND UNHATCHED AREAS
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.43lbs

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WITHOUT NOTICE
WORK ORDER
NO 51828

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3695	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SLIDER ASSEMBLY	NTS
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09/02/05

